

Date: Wednesday, 7/4/2007 3:55:41 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GPS RECEIVER HOUSING
Job Number : 33304	
Estimate Number : 12495	
P.O. Number : N/A	Part Number : D35149
This Issue : 7/4/2007 S.O. No. : N/A	Drawing Number : UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : N/A
Previous Run : 32538	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 7/11/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 2 Um: Each
Comment : Est Rev:A New Issue 06-07-26 JLM	

PROTOTYPE

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 0.1969 sf(s)/Unit Total : 0.3938 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: *103324**B 07-07-10**M 102723*CERTIFICATE OF CONFORMITY
REQUIRED

2.0 WATER JET FLOW WATER JET

*B 07-07-09*

Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: *PR5L*Prog Rev: *PR5L*

Ensure Grain Direction is correct**

2-Deburr if necessary

*mf**07-07-09*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*B 07-07-10*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*En 07/07/10**(x2)*

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

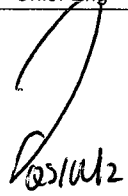
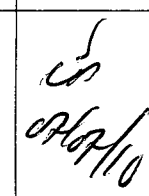
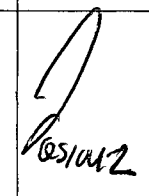
Form Joggle as per Dwg D3514

SB 07/07/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3514-9 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR: <u>33304</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/23	# 2.6	2 parts scrap wrong mat. used 00058" 2024T3 instead of 0.040" 6061T6 R.C. HAMMAN ERROR		-Scrap and replace with correct mat. -Remind Employee to be more cautious when pulling mat. -BATCH # <u>M102723</u>	HB 07 07 10			En 07/07/10

NOTE: Date & initial all entries

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Job Number: 33304

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

FAI NEEDS MORE
DIMS

INSPECT WORK TO CURRENT STEP



CB 07.07.11

**ENGINEERING
APPROVAL**



07.07.16

Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC8

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

07.07.19

10.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.19

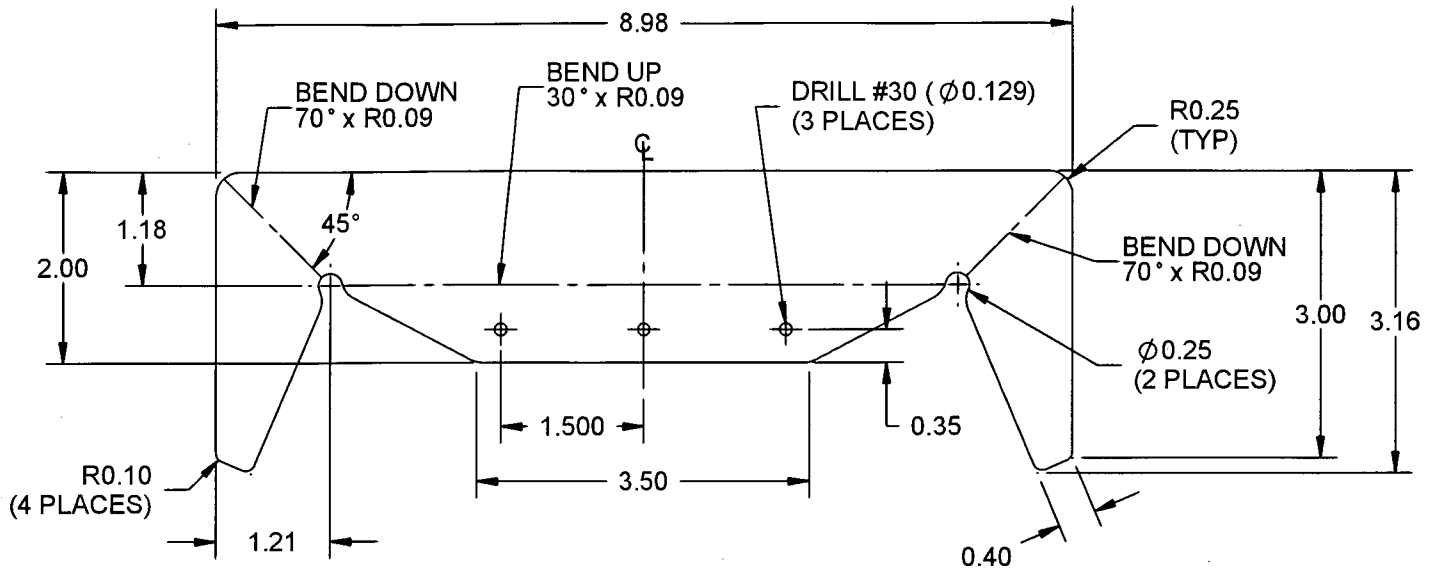
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



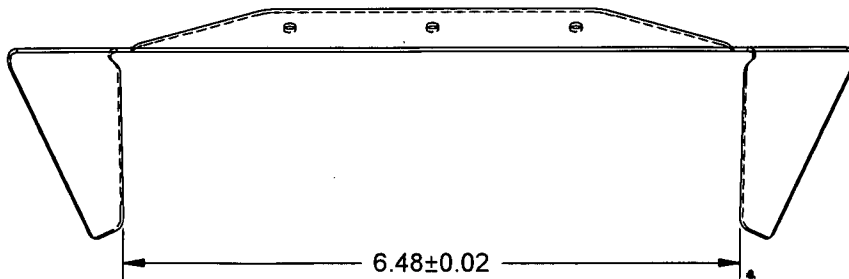
07/07/18

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3514	REV. A SHEET 9 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SCALE 1:2

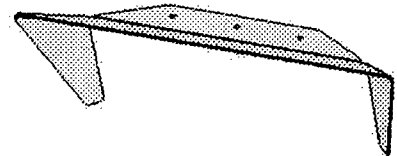


**D3514-9F
FLAT PATTERN**

Est Done



FRONT VIEW



PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
LE 07.06.22

D3514-9 HOOD

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

Receiving Report

Date: 06/11/17
Supplier: Hagha

Batch No: 5102723
Dart P/O: 2988 ← can't match P/O

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☒ No ☐ N/A ☐
Shipment Complete: Yes ☒ No ☐ N/A ☐
QC8 Inspection OK N/A ☐
Work Order N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 JS

Production/Admin: 06/11/21
Date: 06/11/21
Received/Costing: RCF 3075
Initial: BCJ

Location WA

Normal Requirements	Min	0.4	/	0.15	/	0.8	0.04	/	/	Each	Total
	Max	0.8	0.70	0.4	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Test Results		0.65	0.15	0.20	0.05	0.93	0.09	/	/	0.05	0.15

B. MECHANICAL PROPERTY

Test Items	Ultimate Strength	Yield Strength	Elongation
Units	KSI(min)	KSI(min)	%
Normal Requirements	38.0	35.0	10
Test Results	52.8	48.3	14

It is hereby certified that the above material is manufactured in compliance with the specified standards and meets the stipulated requirement.

Authorized Department: Quality Test Department

Inspector: 逢彩燕

Quality Manager: Ke xin Yao

LONGKOU NANSHAN ALUMINUM

Signature: 姚克欣

GENERAL FACTORY



B&715



B5670

INSPECTION CERTIFICATE

CUSTOMER :

YOUR ORDER NUMBER : P01853
OUR ORDER NUMBER : 43725/01
DOCUMENT NUMBER : V/0080117814

DESCRIPTION : T6-QQA-250/11-AMS 4027-ASTM B209/B597 NOT INTENDED FOR USE IN AIRCRAFTS
DIMENSIONS : 144" X 48" X 0.04"
ARTICLE NO. : AL SHEET (STENC) - 6061

COIL NUMBER	CAST NUMBER	CHEMICAL COMPOSITION (%)							
		SI	FE	CU	MN	MG	CR	TI	ZN
		MIN	0,40	0,15		0,8	0,04		
		MAX	0,8	0,40	0,15	1,2	0,35	0,15	0,25
001	1096701		0,67	0,4	0,21	0,07	1,0	0,14	0,02
		OTHERS :	EACH :	MIN	0,05	MAX			
			TOTAL :	MIN	0,15	MAX			

MECHANICAL PROPERTIES				
1 N/MM2 = 1 MPA = 0,1 NBAR = 0,102 KG/MM2 = 0,145 KSI				
/A = REAR END /M = MIDDLE /V = FRONT END /O = RANDOM SAMPLING				
TEST- NUMBER		RM N/MM2	RP02 N/MM2	A %
	MIN MAX			
001	/A	344	290	15
001	/M	342	288	16
01	/V	345	287	15

HEAD OF LABORATORY,
XAVIER SCHELTJENS

BY *Idy (patrice)*
KATHY JANKOVICH, CERTIFICATION PROCESSOR